

* CUSTOM *

HUSH.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9710
Job Sheet 169109



Part No: 646.9710

Job Qty: 2 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/30/17

Job Tracking No:

Created By: Mario Poulin

Due Date: 12/7/17

Type: SOLD

Description:

Note: DWG REV D2 SHEETS 2, 3, 4 IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Pto →
NLR # 17-6707
ECR # 17-137/138

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/6/17	0.00	0.00	Start Up Machining-1		
100	Bandsaw	2 pcs		12/6/17	0.00	0.01	Bandsaw1		
110	CNC Vertical Machining	2 pcs		12/6/17	0.22	1.00	HAAS1-1		
120	QC	2 pcs		12/6/17	0.00	0.00	QC2 Machining-1		
130	QC	2 pcs		12/6/17	0.00	0.00	QC8 Machining-1		
140	Outsource	2 pcs		12/6/17			ATG001-VC		
150	Packaging	2 pcs		12/6/17	0.00	0.00	Packaging2		
155	QC	2 pcs		12/6/17	0.00	0.00	QC5		
160	SprayPaint	2 pcs		12/7/17	0.00	0.33	Spray Paint		
165	QC	2 pcs		12/7/17	0.00	0.00	QC14		
180	Packaging	2 pcs		12/7/17	0.00	0.00	Packaging3-1		
190	QC21-SA	2 Ea		12/7/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 7.425"

Descriptions: 110 - 1-Machine per folio FB130

140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.9700

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S1.000X5.000	1	27	0	0

Part Specifications

Specifications could not be found.

Plex 11/30/17 4:00 PM dart.poulin.mario

To BO USED ON w/o 169108

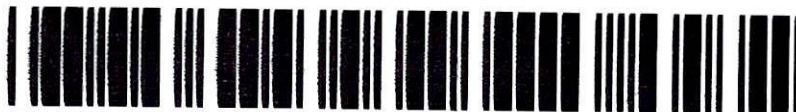
M138451 → 15 piece → 1.25 piece

50 17240

DART
AEROSPACE
S017739

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Body

PART NO: 646.9710

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/05/17

Job No: 169109

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : 2017/12/14		Step #:		QTY Effective :			MRB (QSI042) Approval 5/12/14 Per Analysis email																																																																
Description Work Order Deviation				Disposition				Completed By																																																															
Due to customer complaint regarding Fit issue with 647-1401 Upper Cutters Assy to 647-2111 Upper Rail. • Drawings do not match match. & RC Drawing issue.				- ATTACHED APPROVAL to modify Hole Pattern on 647-1401 to match 647-2111. From Pablo. • Modified Part. * SEE NCR <u>17-6707</u> <u>ECR 17-137/138</u>				Lead hand / Supervisor Approval Verification																																																															
								QC / QA Coordinator Approval 5/12/14																																																															
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Eric Downing

From: Marc Bellavance
Sent: Wednesday, December 13, 2017 8:26 AM
To: Eric Downing
Cc: Patrick Duval; Marcel Daviau; Pablo Bravo
Subject: FW: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Eric,

Is this the approval you needed from Pablo?

Please advise.

Thanks,
Marc

From: Marc Bellavance
Sent: Tuesday, December 12, 2017 5:28 PM
To: Pablo Bravo <pbravo@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>
Subject: Re: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Thanks Pablo.

This is my recollection too. And we already have an NCR for this. I'm thinking that whoever issues the Form One needs to explain how the part deviates. My suggestion: hole pattern at the base of the cutter corrected to match 647.2111 Rail. Something like that's.

Marc
Sent from my iPhone

On Dec 12, 2017, at 17:25, Pablo Bravo <pbravo@dartaero.com> wrote:

Hi Marc,

The deviation looks acceptable to me. How do you want to handle this? In instances like these, QC has issued an NCR to cover the parts and then explained the deviation within the NCR.

-Pablo

From: Marc Bellavance
Sent: Tuesday, December 12, 2017 2:22 PM
To: Pablo Bravo <pbravo@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>
Subject: FW: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855
Importance: High

Hi Pablo,

Please reference issue below (date stamp Thursday, November 30, 2017 11:17 AM highlighted in yellow). The PDFs referenced in that emails are attached. I've also attached copies of the ECR I will be addressing.

We had customer made cutter bases manufactured for the 2 customers experiencing fit issues. I've attached a photo showing that the cutter now fits the 647.2111 rail. However, Quality advised that they cannot issue an Form One for the part unless you provide some sort of approval on the minor deviation. We're looking at shipping the replacement upper cutter assy on Thursday so we need your approval. Can you please review and respond?

Feel free to call me if you want to discuss further.

Heading home but you can reach me at 613 677-4570.

Cheers,
Marc

Note:

This is a VERY hot case, especially with a customer (ADAC) who is not impressed. Our response is impacting future prospect and we really need to be responsive. Alain, SteveG and Adrien are really pushing for a resolution on this.

From: Jacob Becker
Sent: Thursday, November 30, 2017 6:53 PM
To: Marc Bellavance <mbellavance@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Hi Marc,

The 647.1400 drawing definitely needs to be updated to fix the issue you have described below. It should be the 646.9701 cutter sub assembly as the bubble references in the view.

There is definitely a mix up in the BOM. There also is no description for F/N 7 on the cutter assembly drawing.

-Jacob

From: Marc Bellavance
Sent: Thursday, November 30, 2017 11:17 AM
To: Jacob Becker <JBecker@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Hi Jacob,

This is about Customer Support Cases 10132 and 10133. Customer reported that the hole pattern in 647.1401 Upper Cutter Assy does not match the hole pattern on existing aircraft rail. Quality reported the same issue trying to test fit 647.1401 Upper Cutter Assy onto 647.2111 Upper Rail.

Upon closer look, there is another issue with 647.1401 Upper Cutter pulled onto 647.1301/.1302 CCKs: Per 647.1400 drawing, the Cutter Sub Assy of 647.1401 Upper Cutter is of P/N 646.9703. The latter pulls 646.9713 Body which features 5 mounting holes and made for installation into a u-channel type rail. This configuration cannot fit the 647.2111 Upper Rail (or existing similar L-shaped rail factory installed by Airbus). Not sure how this happened but the 647.1401 Upper Cutter found in stock and the one sent to our customer features a 646.9701 Cutter Sub Assy which pulls a 646.9710 Body. The latter features 4 mounting holes and a channel to fit an L-shaped rail (like 647.2111 Upper Rail). However, as per the issue outlined above, the hole pattern does not match the 647.2111 Upper Rail.

Please see attached PDFs where one of them is showing a SolidWorks screenshot where the mounting holes on 646.9710 were corrected to match the 647.2111 Upper Rail. The other PDF offers red lines for manufacturing purposes.

We have 2 customers with the same issue so please approve manufacturing of qty(2) custom-made 646.9710. Changes highlighted in 646.9710 Marcups.pdf.

An ECR is in the works. We will also need to put 647.1300/.1301/.1302 and 647.1400/.1401 under review.

Regards,

MARC BELLAVANCE

Mechanical Designer / Technical Support

DART AEROSPACE

T 1 613 632 5200 > 243

M 1 613 676 0992 > Customer Support

M 1 613 677 4570 > Direct

F 1 613 632 9311

S [marcbellavance](mailto:marcbellavance@dartaero.com)

1 800 556- 4166

www.dartaerospace.com

<image001.jpg>

Technical Publications: Verify Revision Status/Download [HERE!](#)

From: Patrick Duval

Sent: Wednesday, November 29, 2017 6:41 PM

To: Marc Bellavance <mbellavance@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Cc: Lisa McMachen <lmcmachen@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>

Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Sorry, I forgot we will also need to replace the p-seal 601.3011

Pat.D

From: Patrick Duval

Sent: Wednesday, November 29, 2017 5:58 PM

To: Marc Bellavance <mbellavance@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Jean-Luc Menard (<jmenard@dartaero.com>)

Cc: Lisa McMachen <lmcmachen@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>

Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Linda/Mario,

I will bring the kit back to packaging in order to ship by Friday, but the following is needed

- Kit will need to be completely repackage using the Dart plastic bags.
- Parts to be added are:
 - 647.1402 (Replacement)
 - 601.2198 qty3
 - 600.1012 qty 1
 - 600.0991 qty 1
 - 600.0990 qty 1
 - 601.1983 qty 4

I will also want a QC4 to be perform before closing of the box, just to make sure we didn't miss anything.

Pat Duval

QC Coordinator

T: 1-613-632-5200 ext. 288

F: 1-613-632-5246

www.dartaero.com

pduval@dartaero.com

<image002.jpg>

From: Marc Bellavance

Sent: Wednesday, November 29, 2017 3:49 PM

To: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>

Cc: Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Adrien Dillard <adillard@dartaero.com>; Steve SG. Ghaleb <sghaleb@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Support San Diego <support.ca@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Kinga Lysiak <klysiak@dartaero.com>

Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Importance: High

Linda/Mario,

Here's a recap on the recent situation brought to my attention earlier today:

- Kit P/N 647.1301 is for the most part complete however:
 - Some hardware is missing.
 - Corrosion damage was found on Lower Cutter P/N 647.1402.

- Upper Cutter P/N 647.1401 cannot be fastened to 647.2111 Upper Rail (the hole pattern at the base of P/N 647.1401 does not match the hole pattern on P/N 647.2111).

Short Term Solution:

- Addition of missing hardware to Kit P/N 647.1301 and replace shelf-life parts.
- Build a replacement 647.1402 Lower Cutter and scrap parts that are corroded. This is needed tomorrow or by Friday.
- Customer Support would like to proceed with partial shipment on December 1 (latest) of Kit P/N 647.1301 minus 647.1401 Cutter Assy (Upper).
- DART to manufacture a 647.1401 Cutter Assy (Upper) that shares the same hole pattern as the one found on 647.2111 Upper Rail and aircraft on a custom work order. As discussed, lead time is a minimum of 2 weeks (programming, machining, anodizing, and final assy). Note that we have another CCK with same hole pattern issue (NHV).

Long Term Solution:

DART to revise its manufacturing drawing to ensure 647.1401 Cutter Assy (Upper) shares the same hole pattern as the one found on 647.2111 Upper Rail and aircraft.

Please confirm that:

1. We can partial ship Kit P/N 647.1301 as outlined in "Short Term Solution" presented above by December 1.
2. We can ship custom made 647.1401 Cutter Assy (Upper) in 2 weeks from now.

Thanks,
Marc

From: Marc Bellavance

Sent: Monday, November 27, 2017 6:38 PM

To: Steve SG. Ghaleb <sghaleb@dartaero.com>

Cc: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Adrien Dillard <adillard@dartaero.com>

Subject: Re: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Action for this is on Quality/Manufacturing. I will inform our customer of our plan by email and confirm timeline with customer as soon as I have a ship date confirmed by Manufacturing.

Marc
Sent from my iPhone

On Nov 27, 2017, at 18:35, Steve SG. Ghaleb <sghaleb@dartaero.com> wrote:

Thanks Marc.

Who has that action? We need to confirm first thing in the morning if the kit is complete...if not, we need to get it complete ASAP.

We need to let the customer know our exact plan of action and timeline immediately.

Thanks
Steve

From: Marc Bellavance
Sent: November 27, 2017 6:33 PM
To: Steve SG. Ghaleb <sghaleb@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Adrien Dillard <adillard@dartaero.com>
Subject: Re: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Steve,

We need to inventory the kit we have in stock ASAP. If complete, then we ship. If incomplete, then we need it completed and shipped ASAP. We can take care of having their incomplete kit returned on an RMA later...

Marc
Sent from my iPhone

On Nov 27, 2017, at 18:10, Steve SG. Ghaleb <sghaleb@dartaero.com> wrote:

Team,

We need a resolution for this fast. This is a highly critical customer and opportunity.

What is the next step and how fast can we get this resolved?

Steve

From: Marc Bellavance <mbellavance@dartaero.com>
Date: 27 November 2017 at 17:17:45 GMT
To: Linda Lacelle <llacelle@dartaero.com>, Mario Poulin <mpoulin@dartaero.com>, Patrick Duval <pduval@dartaero.com>, Eric Downing <edowning@dartaero.com>
Cc: Lewis Brooks <lbrooks@dartaero.com>, Sian Willems <swillems@dartaero.com>, Lisa McMachen <lmcmachen@dartaero.com>, Support Hawkesbury <support.on@dartaero.com>
Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Thanks Linda!

So what do you suggest here:

1. Should we build a new kit from scratch and send to customer?

2. Or have customer inventory what he received and we provide what is missing?

Due to the urgency, Option 1 is probably the best so what would be our lead time here? Either way, Customer Support Case # 10124 opened, NCR to follow...

Marc

From: Linda Lacelle
Sent: Monday, November 27, 2017 12:09 PM
To: Marc Bellavance <mbellavance@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Eric Downing <edowning@dartaero.com>
Cc: Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>
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All I can tell you, that this was long time ago and it sat open with a w/o to add parts, and didn't get done until Sept...not sure anyone actually checked to see if it was up to date...same goes for the other kit in stock

L

From: Marc Bellavance
Sent: Monday, November 27, 2017 12:06 PM
To: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Eric Downing <edowning@dartaero.com>
Cc: Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>
Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Can someone please provide me with an update on this?

Marc

From: Support Hawkesbury
Sent: Friday, November 24, 2017 9:42 AM
To: Linda Lacelle <llacelle@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Eric Downing <edowning@dartaero.com>
Cc: Support Hawkesbury <support.on@dartaero.com>; Lewis Brooks <lbrooks@dartaero.com>; Sian Willems <swillems@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>
Subject: FW: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855
Importance: High

All,

Per email below, customer claims to have received an incomplete 647.1031 CCK Kit; for the most part, the fixed provisions would be missing from their kit.

We have qty(1) 647.1031 in stock. Can we please verify completeness asap?

Marc

From: Lewis Brooks
Sent: Thursday, November 23, 2017 11:16 AM
To: Support Hawkesbury <support.on@dartaero.com>
Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855
Importance: High

Hey Marc,

As this is an AOG can we ship the other kit we have in stock, while we work out what happened with the other one?

Thanks
Lewis

From: Support Hawkesbury
Sent: Wednesday, November 22, 2017 7:37 PM
To: Lewis Brooks <lbrooks@dartaero.com>
Cc: Support Hawkesbury <support.on@dartaero.com>
Subject: RE: PO-037262-2017 / Shipping No: 00624 / Tracking No. 1Z6645W10499697855

Hey Lewis,

Looking into this one; sorry for the delay.

Cheers,

MARC BELLAVANCE

Mechanical Designer / Technical Support

DART AEROSPACE

T 1 613 632 5200 > 243

M 1 613 676 0992 > Customer Support

M 1 613 677 4570 > Direct

F 1 613 632 9311

S marcbellavance

1 800 556- 4166

www.dartaerospace.com

<image001.jpg>

Technical Publications: Verify Revision Status/Download
[HERE!](#)

From: Lewis Brooks

Sent: Thursday, November 16, 2017 8:54 AM

To: Support Hawkesbury <support.on@dartaero.com>

Subject: FW: PO-037262-2017 / Shipping No: 00624 /
Tracking No. 1Z6645W10499697855

Hi Team,

We shipped a 647.1031 kit to ADAC below, but it
doesn't seem to have any fixed parts and some of the
deflectors are missing.

I believe we have another kit in stock, is it possible to
double check to see if there's anything else that
should've been sent?

Thanks

Best regards,

Lewis Brooks

Inside Sales Representative

EMEA, Russia & CIS

<image002.png>

DART AEROSPACE

1 Bell Street, G01

Maidenhead

Berkshire, UK

SL6 1BU

T +44 (0) 1628 421 519

M +44 (0) 7447 811 810

E lbrooks@dartaero.com

www.dartaerospace.com

<image001.jpg>

From: Kippnich, Markus [<mailto:Markus.Kippnich@alt-heliservice.de>]

Sent: Thursday, November 16, 2017 12:56 PM

To: Oliver Heliswiss <oliver@heliswiss.es>

Cc: Ackenhausen, Marco <Marco.Ackenhausen@alt-heliservice.de>; Dart Sales Heliswiss

<dartsales@heliswiss.es>; Lewis Brooks

<lbrooks@dartaero.com>

Subject: PO-037262-2017 / Shipping No: 00624 /
Tracking No. 1Z6645W10499697855

Hello Diego,

pls. find attached the shipping documents and
the pictures of the delivered parts.

Can you please check where are the non-
delivered parts?

Thank you in advance.

Mit freundlichen Grüßen / Best Regards

Markus Kippnich

Clerk purchasing department
purchasing department

<image003.jpg>

ADAC Luftfahrt Technik GmbH
Richthofenstraße 126
53757 Sankt Augustin
Germany

E-Mail: Markus.Kippnich@alt-heliservice.de

Web: www.alt-heliservice.de

Phone: +49 2241 9279903

Fax: +49 2241 927954

CEO: Thomas Hütsch

Authorized Officers: Stephan Günther, Cornel

Type of company:
Limited Liability Company with seat in Sankt Augustin
district court Siegburg with number HRB 3605

VAT_reg.No: DE 811358488

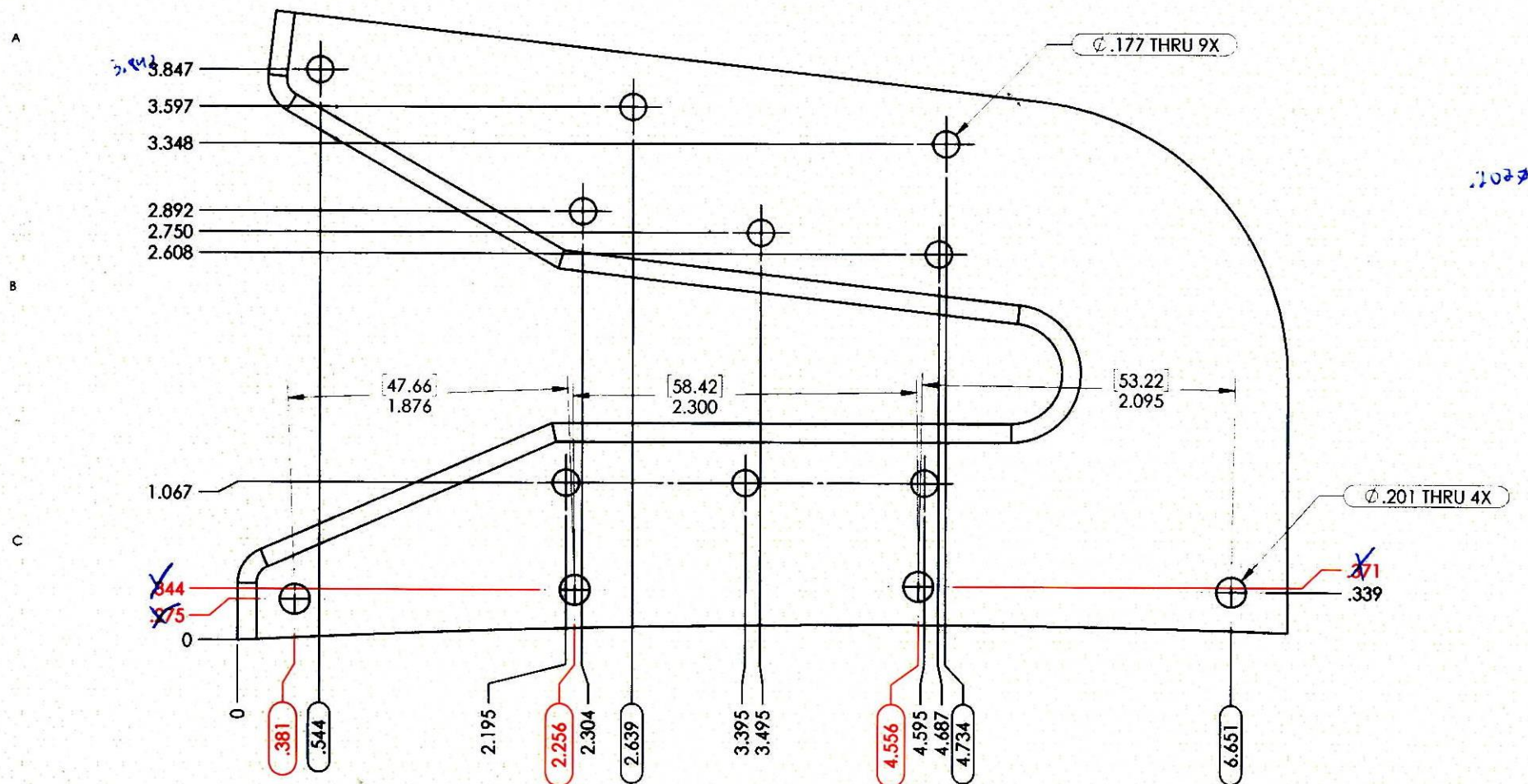
EASA Approvals: PART 145 - DE.145.0058

PART 21 - EASA.21J.368

PART M - DE.MG.0058

1 2 3 4 5 6 7 8

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HOLE LOCATIONS +/- .002

646.9710

ORIGINAL DATE: 05-28-07
 DRAWN BY: R. ROSANO
 CHECKED BY: P. BRAVO
 DRAWING APPROVAL: P. BRAVO
 CONTRACT NO.

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 3 PLACE DECIMALS .001
 2 PLACE DECIMALS .005
 ANGLES .5°

REV. C1
 SCALE: NONE
 SHEET 4 OF 6

DART AEROSPACE LTD		Work Order: 169/09
Description: Body		Part Number: 646.9710
Inspection Dwg:	Rev:	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.130 x 45°	+/- .010 x 0.5°	.128 x 45°	✓		Vernier	
1.500	+/- .005	1.500	✓		Vernier	
.352	+ .005 / - .002	.354	✓		Vernier	
.10 x 45°	+/- .010 x 0.5°	.106 x 45°	✓		Vernier	
.875	+/- .005	.870	✓		Mr. micrometer	
.700	+/- .005	.701	✓		Vernier	
5.500	+/- .005	5.502	✓		Vernier	
.660	+/- .005	.658	✓		Vernier	
.660	+/- .005	.660	✓		high gage	
.275	+/- .002	.275	✓		high gage	
.339	+/- .002	.337	✓		high gage	
.344	+/- .002	.344	✓		high gage	
.371	+/- .002	.371	✓		high gage	
1.067	+/- .002	1.067	✓		high gage	
2.608	+/- .002	2.608	✓		high gage	
2.750	+/- .002	2.750	✓		high gage	
2.892	+/- .002	2.892	✓		high gage	
3.348	+/- .002	3.348	✓		high gage	
3.597	+/- .002	3.597	✓		high gage	
3.847	+/- .002	3.846	✓		high gage	
.381	+/- .002	.381	✓		high gage	
.544	+/- .002	.544	✓		high gage	
2.195	+/- .002	2.195	✓		high gage	
2.304	+/- .002	2.304	✓		high gage	
2.256	+/- .002	2.258	✓		high gage	
2.639	+/- .002	2.639	✓		high gage	
3.395	+/- .002	3.396	✓		high gage	
3.495	+/- .002	3.496	✓		high gage	
4.556	+/- .002	4.558	✓		high gage	
4.595	+/- .002	4.596	✓		high gage	
4.687	+/- .002	4.688	✓		high gage	
4.734	+ .008 / - .002	4.735	✓		high gage	

Measured by: M. J. [Signature]	Checked by: D. E. [Signature]	QC Inspector:
Date: 2017/12/25	Date: 17-12-06	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

142
201
843



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038553

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Issue P/O to ATG : Hard black anodize/Prime as per dwg 646.3311							
14	169109	646.9710	Body Issue P/O to ATG : Hard black anodize/prime as per Dwg 646.9700	Firmed	12/11/17	2 pcs ✓	0 pcs	2 pcs	\$0.011/pcs	\$0.02 Chng. 12-12-17
15	167986	RB PWC38147-1	Drain Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant	Firmed	12/11/17	1 pcs ✓ 2 pcs.	0 pcs	1 pcs	\$0.011/pcs	\$0.01 Chng. 12-12-17.
16	168869	RB T103311- 101	Sleeve Tool -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1 WATER SEAL	Firmed	12/11/17	2 pcs ✓	0 pcs	2 pcs	\$0.011/pcs	\$0.02 Chng. 12-12-17
Grand Total:										\$1,338.23

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 12/12/17 9:01 AM dart.gagnon.michelle



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914269

Date: 11-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
6 ea	Part: 646.3311 Rev: NC RH Half Upper Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22118 PO: PO038553 Line: 12
2 ea	Part: 646.9710 Rev: D Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22120 PO: PO038553 Line: 14
2 ea	Part: RBT103311-101 Rev: Sleeve Tool Job: 22122 PO: PO038553 Line: 16
2 ea	Part: D4977-1 Rev: D Bracket, LH Job: 22101 PO: PO038553 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/12/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may Made in Canada.	

38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914269

Date: 11-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			